

Date: Tuesday, 4/4/2006 1:36:36 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 412 WEB
Job Number : 26537	
Estimate Number : 10466	
P.O. Number : N/A	Part Number : D33891
This Issue : 4/4/2006 S.O. No. : N/A	Drawing Number : D3389 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : C
Previous Run : 26440	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 4/24/2006 Qty: 2 Um: Each
Checked & Approved By : <u>SEE AB</u>	
Comment : Est Rev:A 05.08.31 New issue KJ/JLM Est Rev:B 06-02-08 As per Rev C JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n -1' Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Ext'n -1' Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
1	D2500-3-100	Web Extrusion	B19074 IT 06-04-07

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3389 IT 06-04-07 (2)

2-Drill pilot holes using DT8785 as per Dwg D3389 IT 06-04-07 (2)

3-Open 1X .257" Dia Hole IT 06-04-07 (2)

4-Open Remaining holes to finish size as per Dwg D3389 IT 06-04-07 (2)

5-Deburr IT 06-04-07 (2)

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

20604.12

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 IT 06-04-13 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
060412	2	1 web was drilled to Rev. B (.257 hole is A .625). Human error, drilled .257 on the hex + hole. Dwg is correct on W/O		.257 is now A.625. web See next page.				

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:36:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 WEB

Job Number: 26537

Part Number: D33891

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP06-4-13

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

IS 06-04-13

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

150610/13 (2)

Job Completion





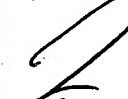


U 06-04-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 12 Date: 06/04/12
 QA: N/C Closed: _____ Date: _____

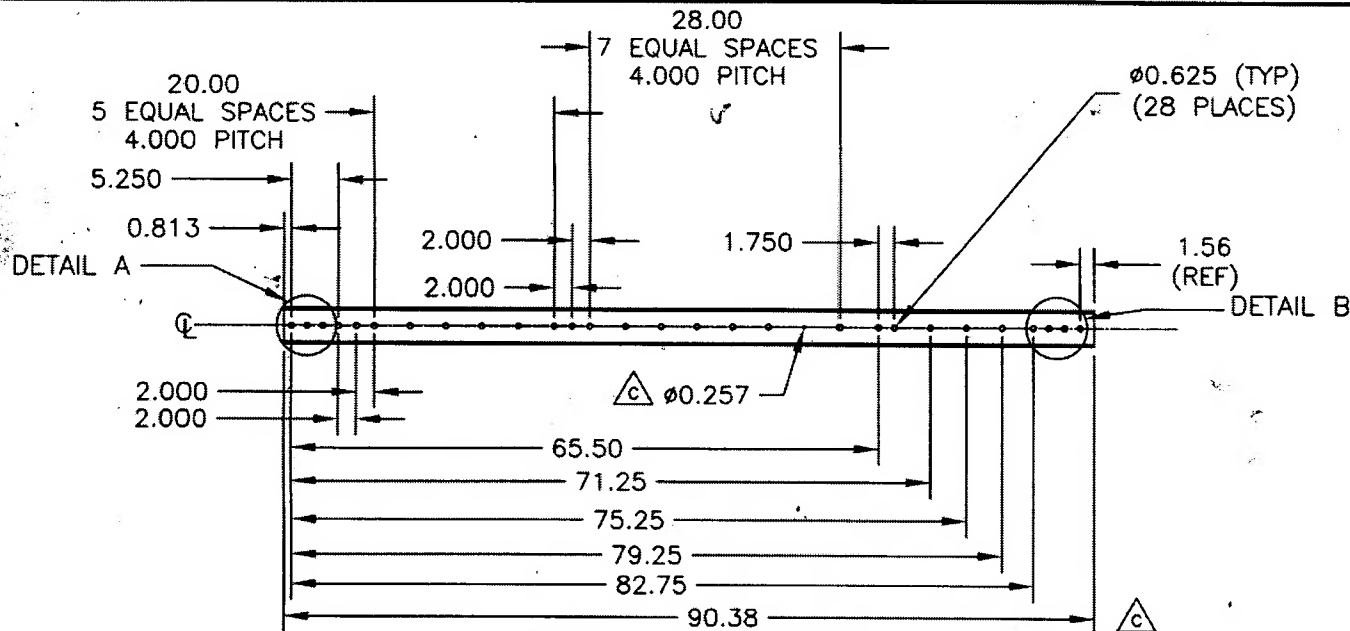
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-04-12	2	1 web was drilled as per Rev.B. Wrong hole was opened up to .257, and is now a .625. Human error, Dwg is correct (Rev.C)		web is acceptable, locating pin for .257 is not even available yet.	 06-04-12	 06-04-12	 06-04-12	 06-04-12

NOTE: Date & initial all entries

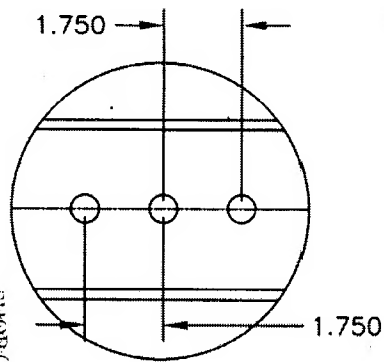
DART

RELEASE
06.01.23

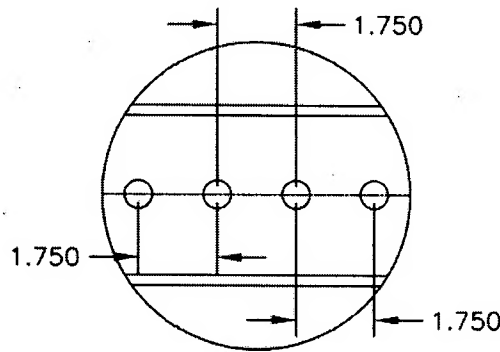
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.01.23	TITLE	412 WEB	REV. C
A	05.02.07	NEW ISSUE		
B	05.06.13	UPDATE DIMENSIONING		
C	06.01.23	DECREASE OVERALL LENGTH, MODIFY HOLE		



D3389-1 DRILLING DETAIL



DETAIL A
(SCALE 1:4)



DETAIL B
(SCALE 1:4)

D3389-1 412 WEB

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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